

Date: Thursday, 3/13/2008 10:18:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RESTRICTOR FITTING
Job Number : 37915	
Estimate Number : 10928	
P.O. Number :	Part Number : D2005013
This Issue : 3/13/2008 S.O. No. :	Drawing Number : D2005 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : C
Previous Run : 33766	Material :
Written By : <u>[Signature]</u>	Due Date : 3/28/2008 Qty: 5 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est. B 99.08.24 Re-format DM/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	AN8328J	Union,Bulkhead-M-Flare
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Elbow,Bulkhead-M-Flare

Pick:

Qty	Part Number	Description	Batch
1	AN832-8J	fitting	M40521

SB 08/03/27

(5)

2.0	D2005003	Restrictor
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Restrictor

Pick:

Qty	Part Number	Description	Batch
1	D2005-003	Restrictor	B 33793

SB 08/03/27

(5)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL / MED FAB

Machine elbow P/N: AN833-8J per Dwg. D2005-013

Press fit D2005-003 restrictor in place as per Dwg. D2005-013

Note:(15° chamfer towards inside of fitting)

Stake restrictor in place using clean ballpeenhammer to tap down edge.

Polish smooth finish

Scribe P/N: D2005-013

FF 08-04-01

SB 08/04/02 (5)

(5)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SB 08/04/02 (5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 7

AS

08/04/02

(X5)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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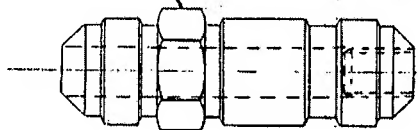
NOTE: Date & initial all entries



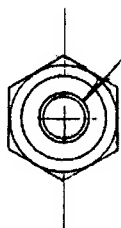
DESIGN BRADLEY	DRAWN BY BRADLEY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2005-013	REV C
DATE 96.04.17		TITLE RESTRICTOR B'HEAD FIT'S	SCALE
C	REDRAWN 96.04.17 BRADLEY <i>[Signature]</i>		

RELEASED
97/09/03 DS

AN 832 - 8J
FITTING



DRILL 11mm DIA
x.500 AS SHOWN



D 2005-003
FORCE FIT AS
SHOWN AND STAKE
IN PLACE.

DETAIL OF D2005-013

SCALE 1:1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37915